

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020972**Date Inspected:** 10-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu hua jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # SEGMENT 13AE

This QA observed ZPMC qualified welding personnel identified as 050242 perform Flux Cored Arc Welding (FCAW) Process on weld joint SEG3007T-110. ZPMC Quality Control Personnel (QC) identified as Mr. Zhong yong gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-ESAB.

This QA observed ZPMC qualified welding personnel identified as 066163 perform Flux Cored Arc Welding (FCAW) Process on weld joint SEG3007AX-002. ZPMC Quality Control Personnel (QC) identified as Mr. Zhong yong gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-ESAB.

This QA observed ZPMC qualified welding personnel identified as 066163 perform Flux Cored Arc Welding (FCAW) Process on weld joint SEG3007AX-009. ZPMC Quality Control Personnel (QC) identified as Mr. Zhong yong gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-ESAB.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA observed ZPMC qualified welding personnel identified as 044772 perform Shielded Metal Arc Welding (SMAW) Process repair welding on weld joint SEG3007AD-025. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang qiang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair and Weld Repair Report B-WR19451.

This QA observed ZPMC qualified welding personnel identified as 037723 perform Shielded Metal Arc Welding (SMAW) Process repair welding on weld joint SEG3007AD-027. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang qiang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair and Weld Repair Report B-WR19453.

This QA observed ZPMC qualified welding personnel identified as 037743 perform Shielded Metal Arc Welding (SMAW) Process repair welding on weld joint SEG3007P-220. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang qiang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair and Weld Repair Report B- WR20134.

OBG # SEGMENT 14E

This QA observed ZPMC qualified welding personnel identified as 218993 perform Submerged Arc Welding (SAW) Process on weld joint SEG3019-004. ZPMC Quality Control Personnel (QC) identified as Mr. Xieming feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3C-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As mention above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
